

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-016968**Date Inspected:** 18-Sep-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Xu Le Feng**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower & OBG Components**Summary of Items Observed:**

On this date Caltrans Office of Structural Materials Quality Assurance Inspector, Sandeep Kumar (QA) was present during the times noted above for observations relative to the work being performed.

TOWER JETTY

This QA Inspector observed the following work in progress

Shielded Metal Arc Welding (SMAW):

Repair welding of a weld joint # 26 as per the weld repair report T-WR3613 located on East tower Lift-3, 99 M backfill plate ESD1 – FASA3 – 2B/E. Welder is identified as 040690. ZPMC Quality Control (QC) Inspector is identified Sun Zi Wang. The welding variables recorded by QC appeared to comply with the WPS – 345+485 – SMAW – 2G (2F) – FCM – REPAIR – 2.

Weld joint # 28 located on East tower Lift-3, 109 M backfill plate ESD1 – FASA3 – 2B/E. Welder is identified as 046769. ZPMC Quality Control (QC) Inspector is identified Fu Wei Min. The welding variables recorded by QC appeared to comply with the WPS – B – T – 4212 – Tc – U4c – 4.

Repair welding of a weld joint # 28 as per the weld repair report T-WR3632 located on South tower Lift-3, 99 M backfill plate SSD1 – FASA3 – 1B/E. Welder is identified as 044511. ZPMC Quality Control (QC) Inspector is identified Sun Zi Wang. The welding variables recorded by QC appeared to comply with the WPS – 345+485 – SMAW – 2G (2F) – FCM – REPAIR – 2.

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Weld joint # 34 located on West tower Lift-3, 109 M backfill plate WSD1 – FASA3 – 2B/E. Welder is identified as 040610. ZPMC Quality Control (QC) Inspector is identified Fu Wei Min. The welding variables recorded by QC appeared to comply with the WPS – B – T – 4313 – Tc – P4.

(See attached photo)

Repair welding of a weld joint # 28 as per the weld repair report T-WR3633 located on North tower Lift-3, 99 M backfill plate SSD1 – FASA3 – 1B/E. Welder is identified as 040365. ZPMC Quality Control (QC) Inspector is identified Sun Zi Wang. The welding variables recorded by QC appeared to comply with the WPS – 345+485 – SMAW – 2G (2F) – FCM – REPAIR – 2.

BAY#10

ORTHOTROPIC BOX GIRDER (OBG) AT BAY#10

This QA Inspector observed the following work in progress

Weld build-up by Fluxcored Arc Welding (FCAW):

Weld build-up being performed using located on Bikepath plate BK5A – BKPL3B as per the Weld Repair report # B-WR14879. Welder is identified as 057180. ZPMC Quality Control (QC) Inspector is identified as Yuan Hui Gang. The welding variables recorded by QC appeared to comply with the WPS – 345 – FCAW – 2G (2F) – Repair – 1.

BAY#11

This QA Inspector observed the following work in progress

Shielded Metal Arc Welding (SMAW):

Weld joint # 13A located on Lift-5 Bracket ND1 – BRSA5 – 2. Welder is identified as 054460. ZPMC Quality Control (QC) Inspector is identified as Liu Dao Feng. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3213 – Tc – U4b.

Weld joint # 9B located on Lift-5 Bracket ND1 – BRSA5 – 2. Welder is identified as 044541. ZPMC Quality Control (QC) Inspector is identified as Liu Dao Feng. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3213 – Tc – U4b.

BAY#12

ORTHOTROPIC BOX GIRDER (OBG) AT BAY#12

This QA Inspector observed the following work in progress

Fluxcored Arc Welding (FCAW):

Weld joint # 01 located on U-rib splice plate SA3051A – 029. Welder is identified as 059443. ZPMC Quality Control (QC) Inspector is identified as Zhao Jian Hang. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2232 – Tc – U4b – F.

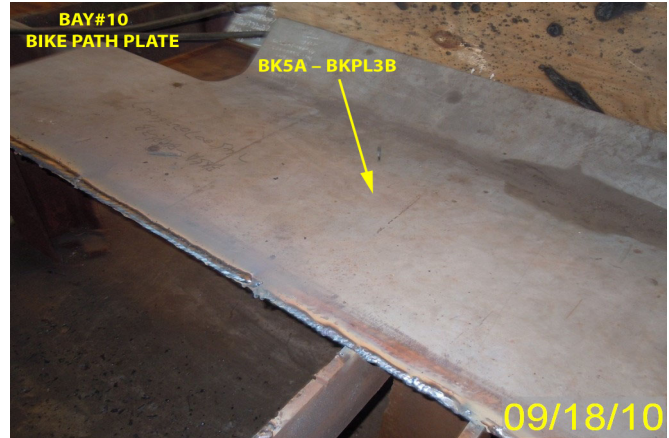
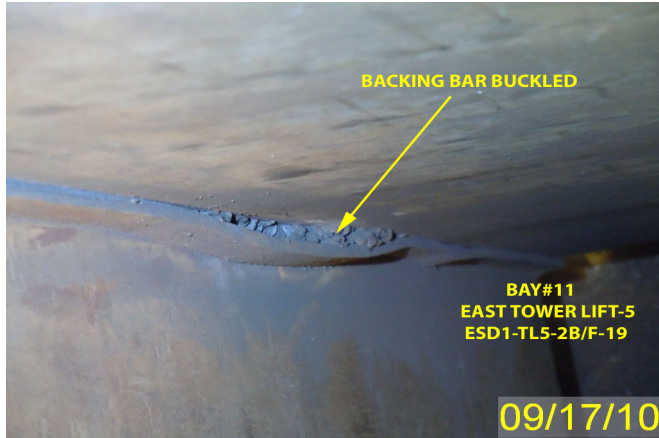
Weld joint # 02 located on U-rib splice plate SA3051A – 032. Welder is identified as 059416. ZPMC Quality

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Control (QC) Inspector is identified as Zhao Jian Hang. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2232 – Tc – U4b – F.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

No Relevant Conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Michael Ng - 15921845703, who represents the Office of Structural Materials for your project.

Inspected By:	Kumar,Sandeep	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer
